

Date: Thursday, 3/27/2008 7:41:50 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS HANDLE WELDMENT ASS'Y, RH
Job Number	: 38222		
Estimate Number	: 10947		
P.O. Number	:	Part Number	: D2480012
This Issue	: 3/27/2008 S.O. No. :	Drawing Number	: D2480 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : LARGE FAB ASSY	Drawing Revision	: A1
Previous Run	: 38089	Material	:
Written By	:	Due Date	: 4/10/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>JD 08.3.27</u>		
Comment	: Est. C1 03.01.09 Added Powder Coat		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2478	Lower Arm
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lower Arm

Pick:

Qty	Part number	Description	Batch
1	D2478	Heli Access Handle	B 38146 4x 08-07 SP

2.0	D2479	Upper Arm
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Upper Arm

Pick:

Qty	Part number	Description	Batch
1	D2479	Heli Access Handle	B 38228 3x 08-07 - SP

3.0	D2481	Lower Mount Plate
-----	-------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lower Mount Plate

Pick:

Qty	Part number	Description	Batch
2	D2481	Mounting Plate	B 38147-8x 08-07 - SP

4.0	D2482	Upper Mount Plate
-----	-------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Upper Mount Plate

Pick:

Qty	Part number	Description	Batch
1	D2482	Mounting Plate	B 23504 - 4x 08-07 - SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/27/2008 7:41:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, RH

Job Number: 38222

Part Number: D2480012

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

B 107051

SP 08-07-2. 4X.

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-07-03 (C)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/02/03 (4) RL B.38222

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 107925

BL 08-07-0

38222
38222
S.032 13.57
#1 398.0 F
#2 --- F
#3 --- F
#4 --- F

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18 08/07/04

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD 38090

18 08/07/04 (XU)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08

Job Completion



MF 08-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

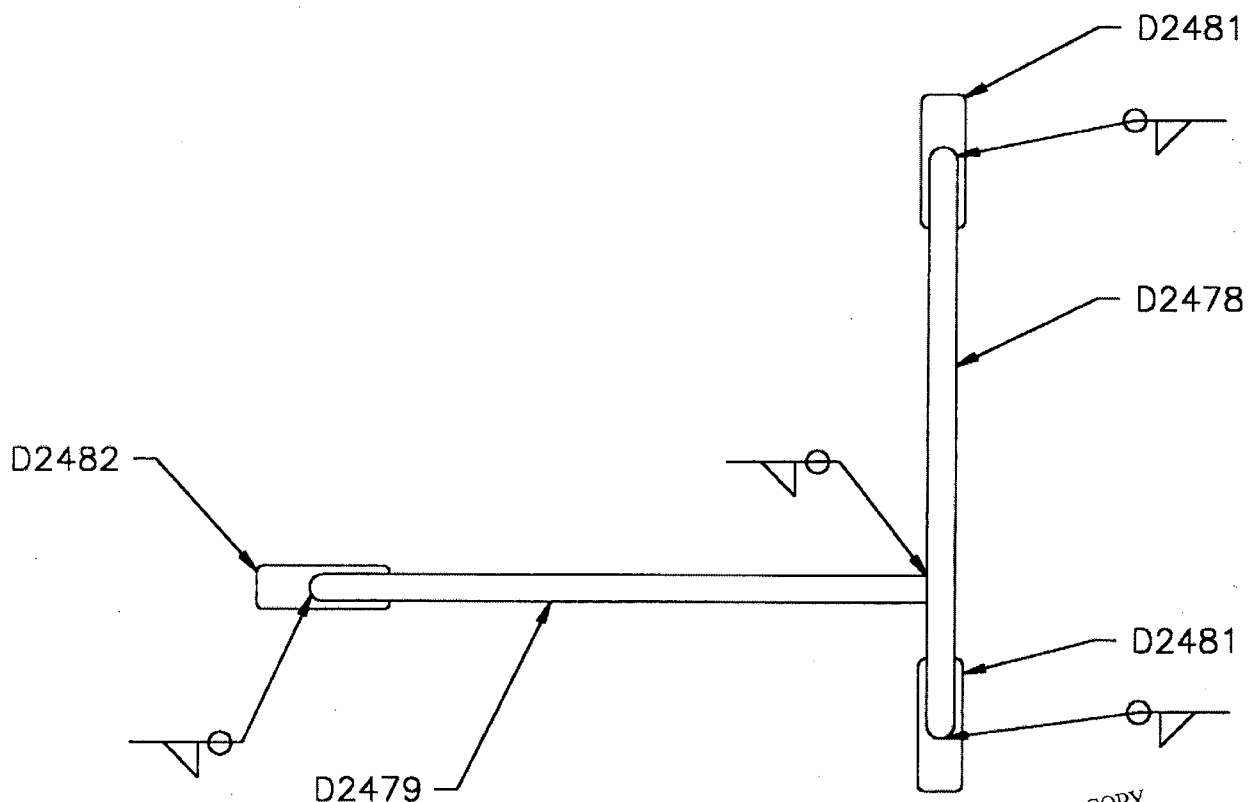
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2480	REV. A SHEET 1 OF 1
DATE 96:05:14	TITLE HANDLE WELDMENT ASSEMBLY		SCALE 6:1
A1	05.06.23		ADDED POWDER COAT

RELEASED
96/06/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
2) POWDER COAT WHITE GLOSS (REF: 4,3,5,2) AS PER QSI 005

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38222